

152730

Monday, November 07, 2016 12:59:38 PM

N900040100

Stop ***NS2***

Approvals: **Process Plan:** VS AT **Date:** 16/11/7 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Work Order ID 152730

Monday, November 07, 2016 12:59:38 PM

152730

Page 2

Item ID: D3266-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Basket Lid Assembly

Start Date: 11/8/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/5/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

125

Pressure Wash per QSI005 4.3

0.00

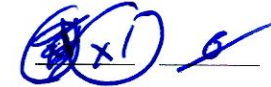
125

HandFinish

Memo

0.00

Hand Finishing

2016/12/07
BEB

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

130

Powdercoat

M 135418.

Memo

0.00

Powder Coating

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2.45
100°
3.15

1 : φ : 16-12-07 33 9.88

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Work Order ID 152730

Monday, November 07, 2016 12:59:38 PM

152730

Page 3

Item ID: D3266-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Basket Lid Assembly

Start Date: 11/8/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/5/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

140

HandFinish

HandFinishing

0.00

Memo

0.00

Wing WalkBatch: 11135819
and Spray Paint black Batch: 11135547 as per Dwg D3266 and QSI 005
4.41 16/12/08

150

150

QC

QC3- Inspect Part Finish

0.00

Memo

0.00

DAS
38
9-89

Quality Control

DEC 09 2016

155

155

Packaging

Identify as per dwg & Stock Location: w/o

0.00

Memo

0.00

D350-607-045/B1527281 16/12/08

Packaging

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
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OTHER : ☐					

Work Order ID 152730

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152730

Page 4

Item ID: D3266-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Basket Lid Assembly

Start Date: 11/8/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/5/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

DAS
21
9-89

DEC 13 2016

DAS
21
9-89

DEC 13 2016

DQA: _____ Date: _____



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Picklist Print

Monday, November 07, 2016 12:59:54 PM

Page 1

Work Order ID: 152730

152730

Parent Item: D3266-041

D3266-041

Parent Item Name: Basket Lid Assembly

Start Date: 11/8/2016

Required Date: 12/5/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B Re-Format 05-11-03 JLM
 IPP Rev:C 08-09-10 revB as per dwg (ecn 08-524) DD verified
 by:EC IPP REV:D
 12.07.27 AS PER DWG REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2232-1 *D2232-1* Basket Hinge		Manufactured	No			100	Each	14.0000	2	2		DEC 04 2016	DAS 24 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				14					
				146596				14		2			
D2236 *D2236* Lid Rib		Manufactured	No			100	Each	4.0000	4	4		DEC 04 2016	DAS 24 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				4					
				149035				4					
D2506 *D2506* Label Plate		Manufactured	No			100	Each	13.0000	1	1		DEC 04 2016	DAS 24 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				13					
				137315				3					
				148587				10		1			

B150483 → 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Picklist Print

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Page 2

Work Order ID: 152730

152730

Parent Item: D3266-041

D3266-041

Parent Item Name: Basket Lid Assembly

Start Date: 11/8/2016

Required Date: 12/5/2016

Start Qty: 1.00

Required Qty: 1.00

D2512-7 Manufactured No

100 Each 12.0000 3 3

D2512-7

Rib

DEC 0 4 2016

DAS
24
9-89

Location

Loc Qty

Loc Code

WA004

12

146487

9

149719

3

3

D2581 Manufactured No

100 Each 88.0000 2 2

D2581

Mounting Bracket

DEC 0 4 2016

DAS
24
9-89

Location

Loc Qty

Loc Code

WA004

88

132771

1

136270

2

139082

2

146089

31

147603

2

148944

26

151990

24

2

D3266-3 Manufactured No

100 Each 2.0000 2 2

D3266-3

Rib

DEC 0 4 2016

DAS
24
9-89

Location

Loc Qty

Loc Code

WA004

2

109894

2

2

D3266-5 Manufactured No

100 Each 6.0000 6 6

D3266-5

Rib

DEC 0 4 2016

DAS
24
9-89

Location

Loc Qty

Loc Code

WA004

6

109895

6

6

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Page 3

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Work Order ID: 152730

152730

Parent Item: D3266-041

D3266-041

Parent Item Name: Basket Lid Assembly

Start Date: 11/8/2016

Required Date: 12/5/2016

Start Qty: 1.00

Required Qty: 1.00

D3825-043

Manufactured No

100

Each

0.0000

2 2

D3825-043

Rib Assembly (Basket End, Lid)

****B153066 → 2 DEC 04 2016**

DAS
24
9-89

D3832-15

Manufactured No

100

Each

0.0000

1 1

D3832-15

Mesh (Lid)

****B154085 → 1 DAS 43 DEC 05 2016**

DAS
43
9-89

D3833-7

Manufactured No

100

Each

8.0000

2 2

D3833-7

Mesh (Lid End)

**** DEC 06 2016 DAS 24 9-89**

Location

Loc Qty

Loc Code

WA006

8

146483

8

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

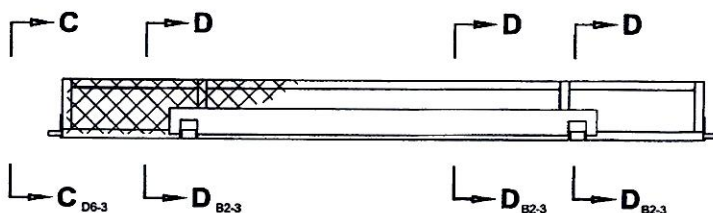
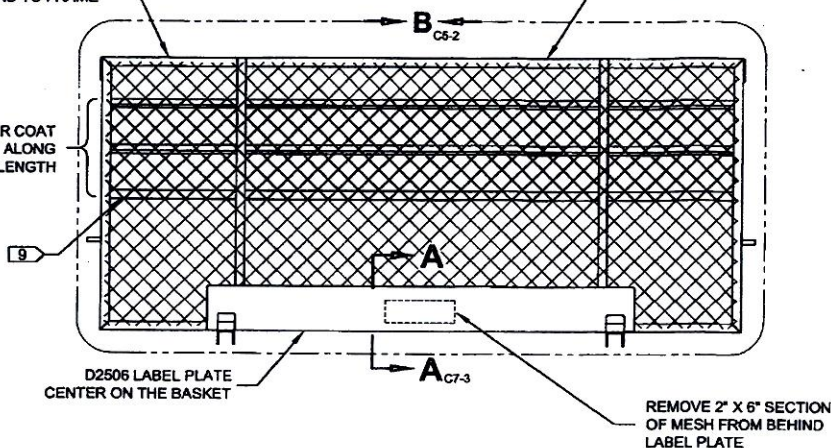
Work Order update only ☐

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SKIN OUTSIDE SURFACE OF LID WITH
D3832-15, TACK WELD
EACH END STRAND TO FRAME

SEE DETAIL B FOR
FRAME ASSEMBLY

AFTER POWDER COAT
FINISH THIS SECTION ALONG
ENTIRE LENGTH



D3266-041 BASKET LID ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
AFTER POWDER COAT, SPRAY PAINT BLACK INSIDE SURFACE AND
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE AS INDICATED
PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) TACK WELD D3832-15 MESH TO FRAME AT EVERY AVAILABLE LOCATION

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152730

QTY	PART NUMBER	DESCRIPTION
X	D3266-041	BASKET LID ASSEMBLY
2	D2232-1	HINGE PLATE
4	D2236	RIB
1	D2506	LABEL PLATE
3	D2512-7	RIB
2	D2581	MOUNTING BRACKET
2	D3266-3	RIB
6	D3266-5	RIB
2	D3825-043	RIB ASSY (BASKET END, LID)
1	D3832-15	MESH (LID, FULL)
2	D3833-7	MESH, FULL LID END FACE



D3833-7
TYP, BOTH ENDS

RELEASED
2012-07-16

C	DWG RE-FORMATED; D2512-7 WAS D3266-7 (ZN D2-2), D3825-043 WAS D3266-1 (ZN C7-2), REMOVED D3266-1, AND -7. REASON: PAR10-50.	MB	12.05.28
B	INCORPORATED A1. DRAWING UPDATED TO CURRENT STANDARDS. SHEET 5 ADDED. RIB MATERIAL WAS 0.060 THICK.	AJS	08.08.15
A	NEW ISSUE	CP	04.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.05.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3266
SHEET 1 OF 4
TITLE BASKET LID ASSEMBLY (350)
SCALE NTS

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WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DQA: _____ Date: _____

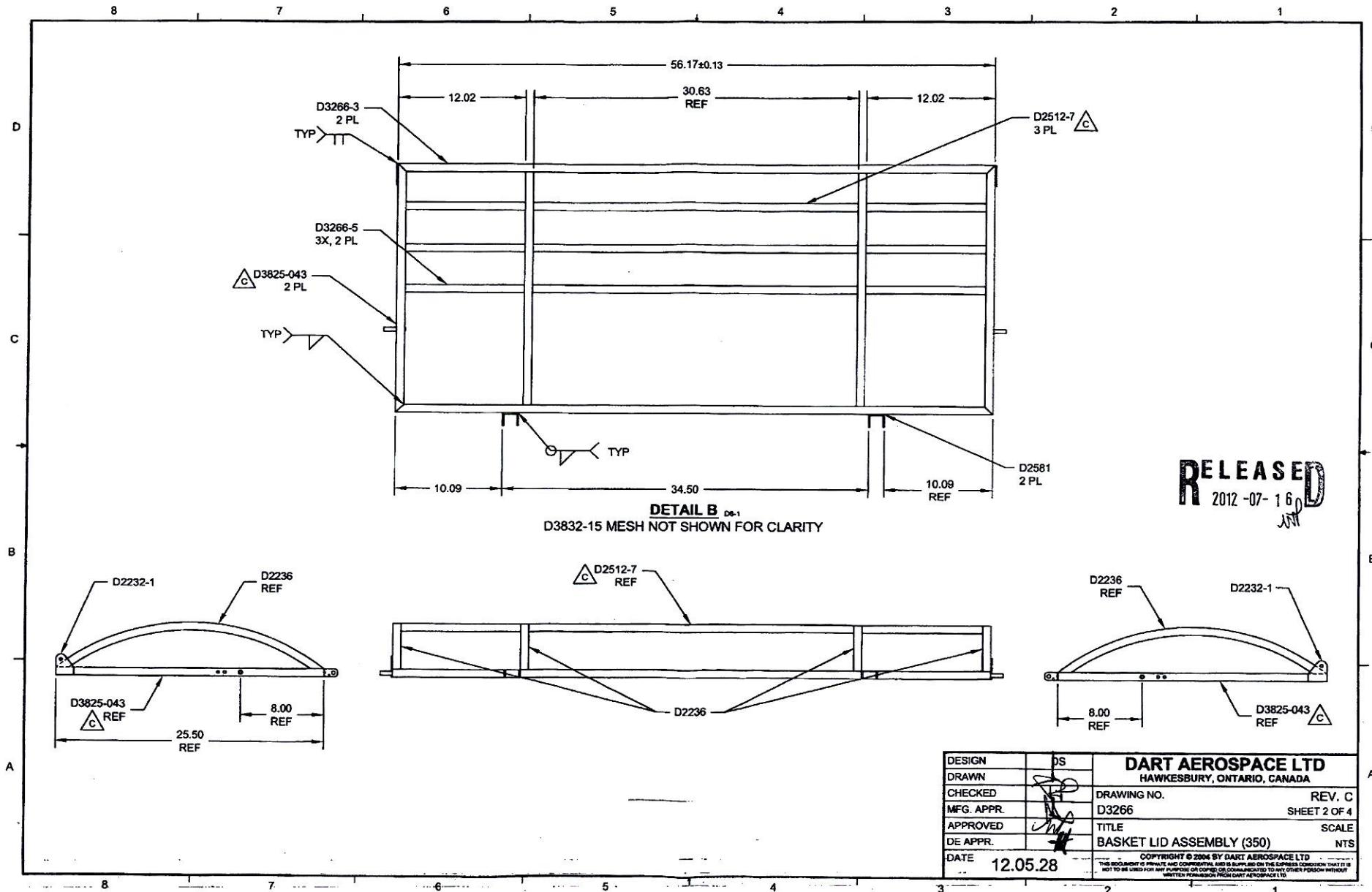


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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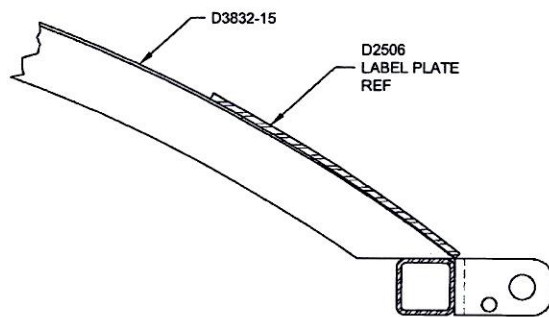
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QA Closed: _____ Date: _____

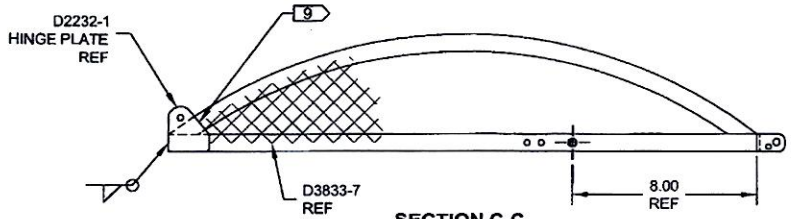
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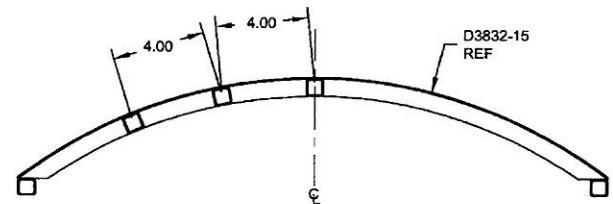
8 7 6 5 4 3 2 1



SECTION A-A
(ROTATED 90° CCW)
SCALE NONE CS-1



SECTION C-C
(BOTH ENDS)
B7-1



SECTION D-D
3 PL B7-1 B5-1

RELEASED
2012-07-16

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A
 - 8) WELD PER DART QSI 004
 - 9) TRIM D3833-7 MESH AS REQUIRED TO ALLOW D2232-1 HINGE PLATE TO SIT FLUSH ON FRAME

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3266	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350)	NTS
DATE	12.05.28	COPYRIGHT © 2004 BY DART AEROSPACE LTD.	
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8 7 6 5 4 3 2 1

DQA: _____ Date: _____

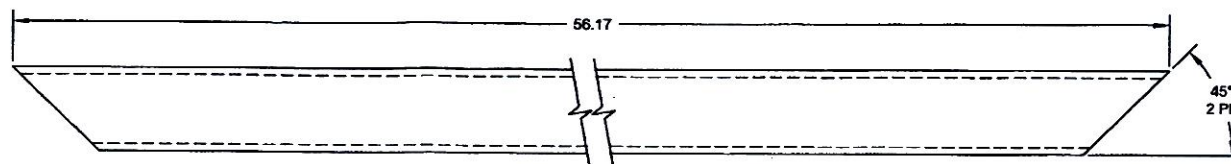
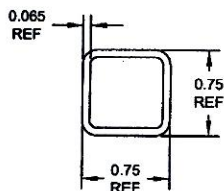
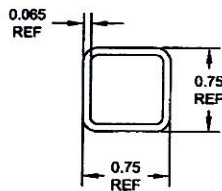


WORK ORDER NON-CONFORMANCE / UPDATE

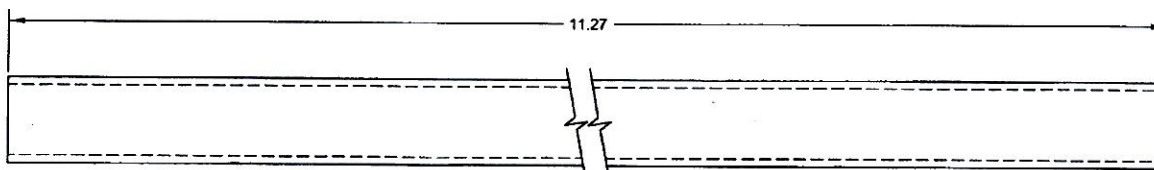
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D3266-3 RIB



D3266-5 RIB

RELEASED
2012-07-16
JW

D3266-3/5 NOTES:

- 1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBING
PER ASTM A554/A269 MILL FINISH, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3266	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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